

Work Order ID 79182-2

79182

Page 1

January-23-12 10:46:56 AM

Item ID: D2803-042

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket Assembly

Start Date: 23/01/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 06/02/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: M.C.J.

Date: 12/01/23 Tooling:

Date:

Stop *NR2*

QC:

Date: SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2803

Rev B

0.00

100

100

Small Fab

Small Fab

Memo

0.00

Small Fab

Press D2805-2 and D2809 into arm as per Dwg D2803

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Quality Control

Memo

0.00

120

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

120

Powdercoat

Powder Coating

Memo

0.00

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

M 119480

3200F

11:10

12/02/08

46

W12

6X0M-12/02/09

Work Order ID 79182

79182

Page 2

January-23-12 10:46:56 AM

Item ID: D2803-042

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket Assembly

Start Date: 23/01/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 06/02/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

Quality Control

150

Small Fab

0.00

150

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D2803.

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

6 6 12/02/09

12/02/28 (5)

12/02/27 (5)

Work Order ID 79182

79182

Page 3

January-23-12 10:46:56 AM

Item ID: D2803-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket Assembly

Start Date: 23/01/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 06/02/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location:

8149

0.00

170

Packaging

Memo

0.00

Packaging

12/02/295

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MF
12-02-29

Picklist Print

January-23-12 10:47:00 AM

Page 1

Work Order ID: 79182

79182

Parent Item: D2803-042

D2803-042

Parent Item Name: Bracket Assembly

Start Date: 23/01/2012

Required Date: 06/02/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2803-2
D2803-2
Bracket

Manufactured No

100 Each 2.0000

**

12/22/08

Location

Loc Qty

Loc Code

ST148

2

75223

2

100 Each 6.0000

1

6

**

12/22/08

D2805-2

D2805-2
Stop

Manufactured No

Location

Loc Qty

Loc Code

GA

6

76186

6

100 Each 147.0000

4

24

**

12/22/08

NAS1515H3

NAS1515H3
Washer

Purchased No

Location

Loc Qty

Loc Code

ST277

147

116373

2

118078

6

118384

11

119438

28

120142

100

120518
202

Picklist Print

January-23-12 10:47:00 AM

Work Order ID: 79182

Parent Item: D2803-042

Parent Item Name: Bracket Assembly

79182

D2803-042

Start Date: 23/01/2012

Required Date: 06/02/2012

Start Qty: 6.00

Required Qty: 6.00

AN3C16A

Purchased

No

150 Each

60.0000

2

12

**

AN3C16A

Bolt

Location

Loc Qty

Loc Code

ST352

60

115835

1

118422

4

118628

13

119641

42

Manufactured

No

150 Each

29.0000

1

6

**

D2809

D2809

Bushing

Location

Loc Qty

Loc Code

GA

7

72735

7

ST018

22

34035

12

77292

10

Purchased

No

150 Each

1,193.000

2

12

**

MS21043-3

MS21043-3

Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

ST300

582

119901

582

ST301

539

118077

2

118614

441

118686

30

119758

66

EP 2/2/12

M120769
(10x)

EP 2/2/12

B80557
(5x)

EP 2/2/12

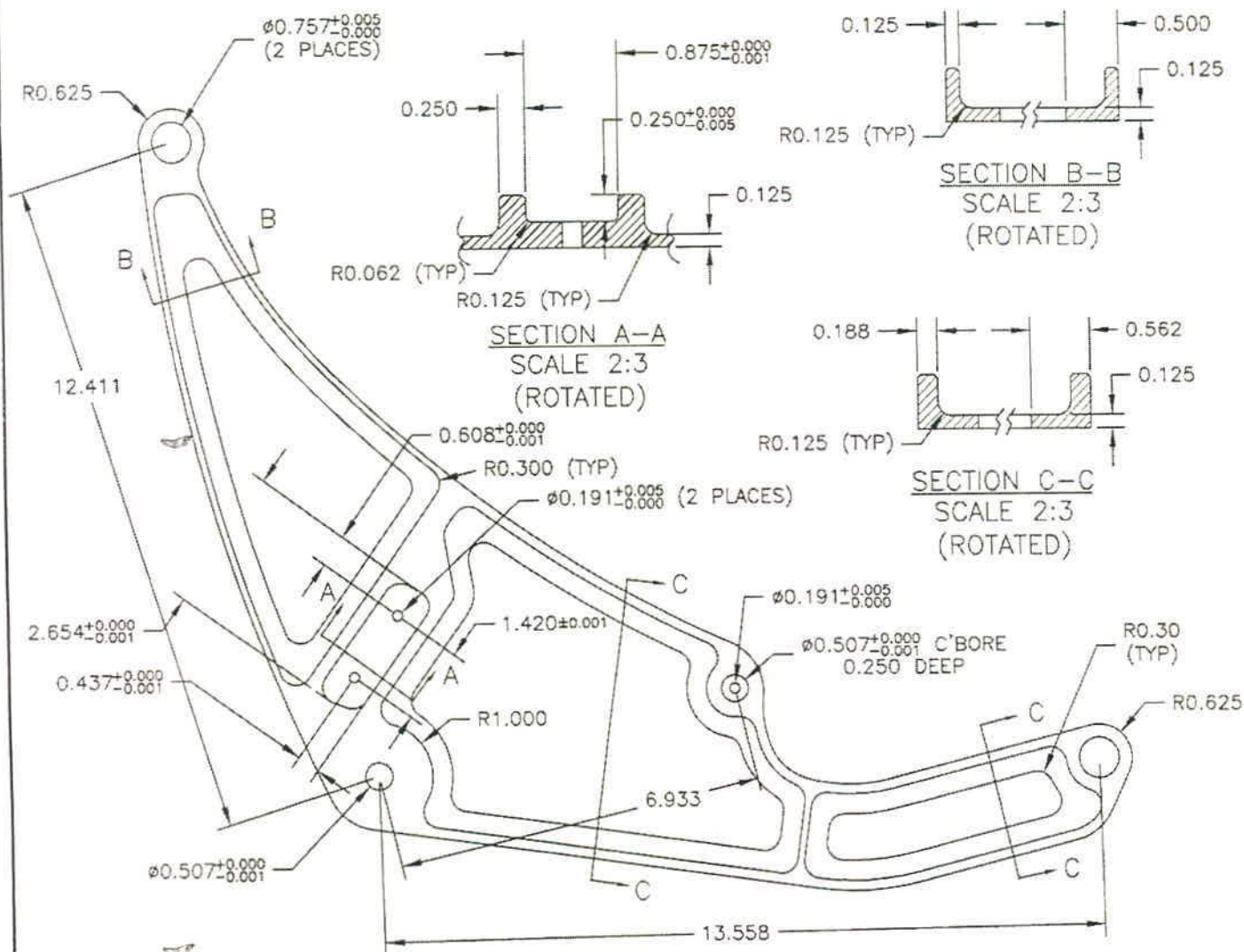
M120693
(10x)



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE	04.11.22			TITLE STA 84 BRACKET	SCALE 1:3
A	00.11.07			NEW ISSUE	
B	04.11.22			ADD CUTOUTS & -043/-044	

RELEASED

05.03.11 *[Signature]*



D2803-1 BRACKET (SHOWN), D2803-2 BRACKET (OPPOSITE)



- 1) MACHINE PER DRAWING FILE "D2803.SLDPRF"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

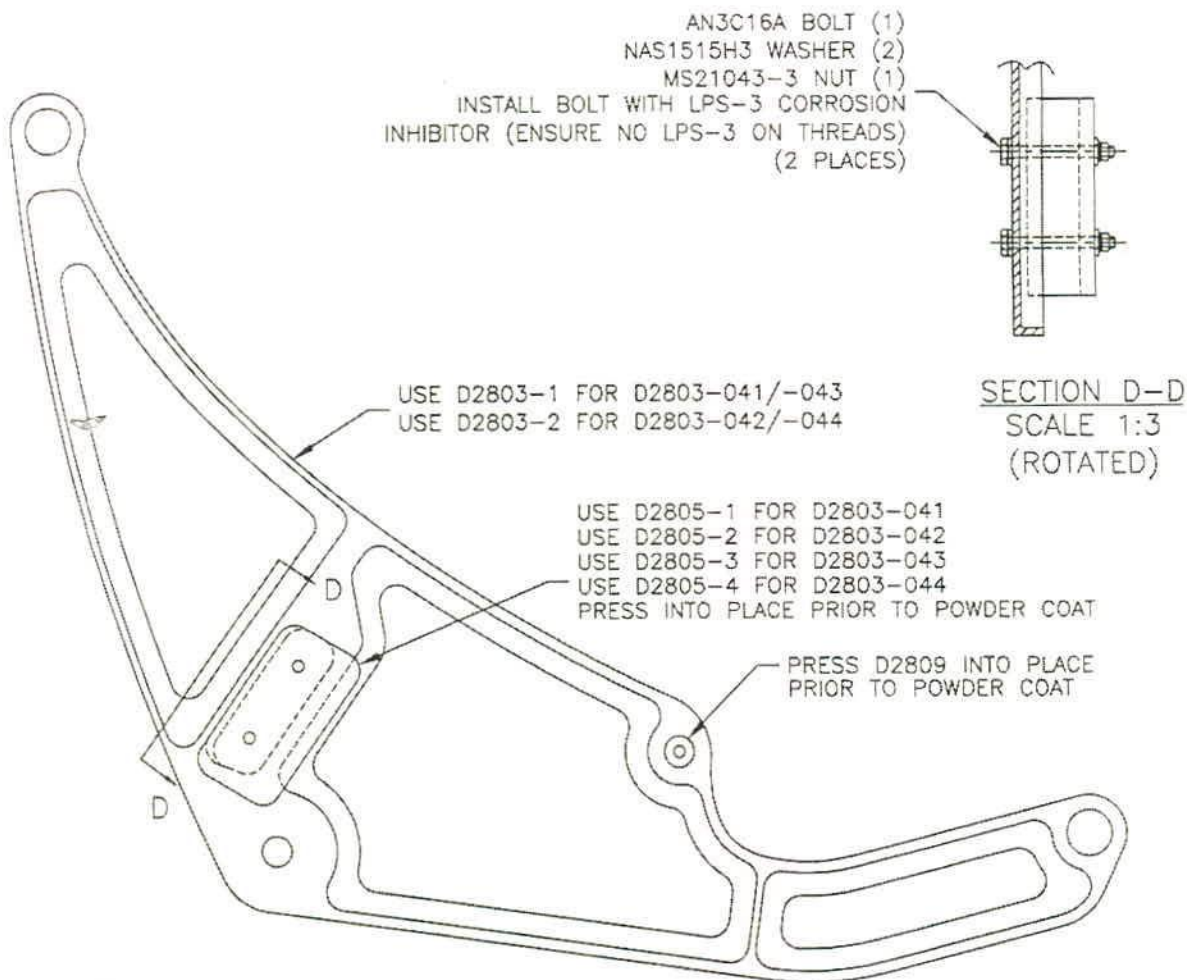
79182 M.C.S
12/01/23

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22	TITLE STA 84 BRACKET		SCALE 1:3



RELEASED

05-03.11

D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.